

Work Order ID 68664

Tuesday, April 19, 2011 3:35:13 PM



Page 1

Item ID: D2013-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Mirror Bracket RH, 212

Start Date: 4/19/2011 Start Qty: 8.00



Cust Item ID:


Required Date: 4/25/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 11-04-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2013

Rev C

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch as per template D2013-T3 and Dwg D2013
2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545
3-Bend (1) tube as per Dwg D2013 using Jig DT8201
Identify as D2013-3.
4-Deburr as required

SB 11/04/20

> m.l

11/04/26

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/04/26

4/11

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68664

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Page 2

Item ID: D2013-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Mirror Bracket RH, 212

Start Date: 4/19/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>W/A</u>	0.00							
Packaging	Memo	0.00				<u>EL</u>	<u>11-428</u>		<u>(X11)</u>
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/4/28

MF
11-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 19, 2011 3:35:20 PM

Page 1

Work Order ID: 68664



Parent Item: D2013-4



Parent Item Name: Mirror Bracket RH, 212

Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 		Purchased	No			100	f	165.0086	1.9473	16.39832			
304 RD Tube .750 x .049W													

Location

Loc Qty

Loc Code

MAT017

165.00863

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

116720

1.833

117030

130.09263

SS 4/20/2011 *(u)*

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

KE 99-0610

NO. 68644

2/11/04-19

DART



DRILL Ø0.257 (TYP)

0.400 (TYP)



VIEW A-A

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

DESIGN	JB	DRAWING BY	RT	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. C
CHECKED	KE	APPROVED	QD	DRAWING NO.	D2013	SHEET 1 OF 3
DATE	99.06.07	TITLE		MIRROR BRACKET		
A		90.10.22		NEW ISSUE		
B		94.06.15		REDRAWN		
C		99.06.07		REDRAWN, CHANGE OF DIMENSIONS		

Copyright 1990 by DART AEROSPACE LTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

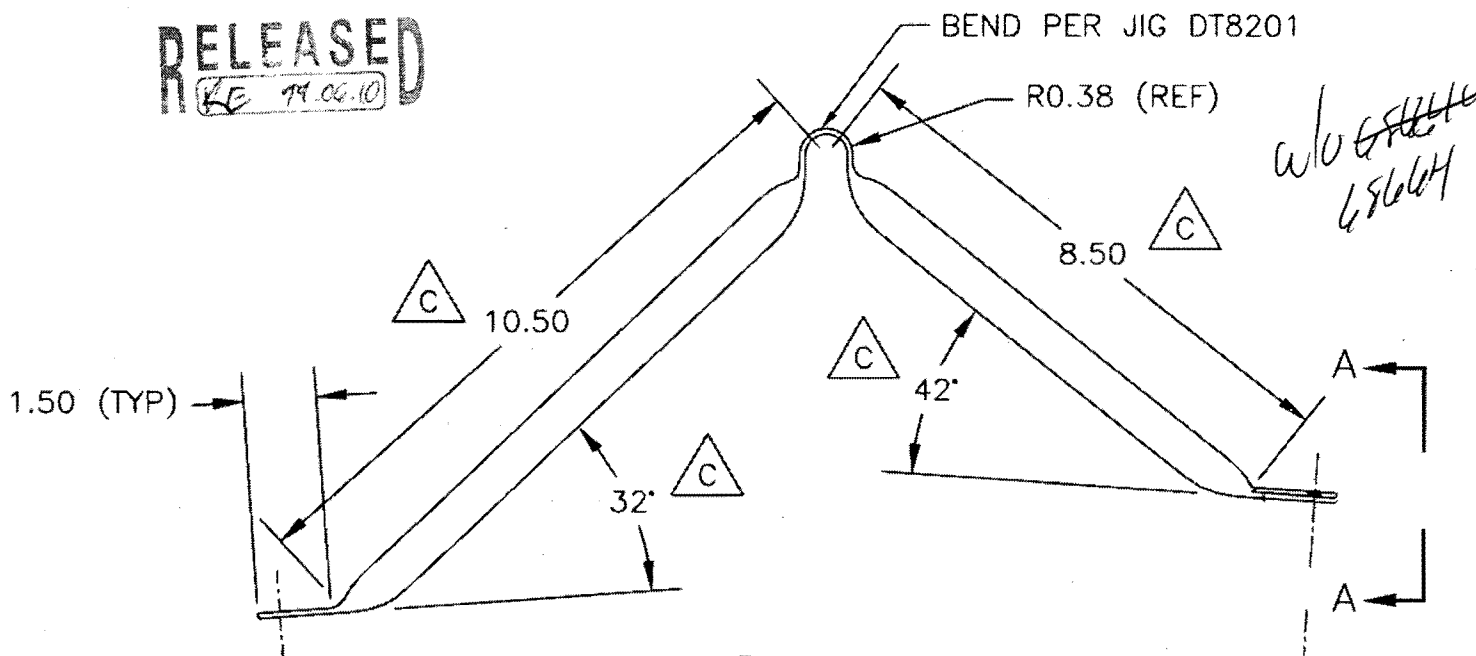
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

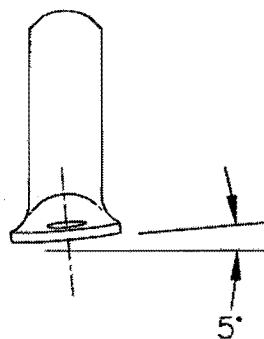
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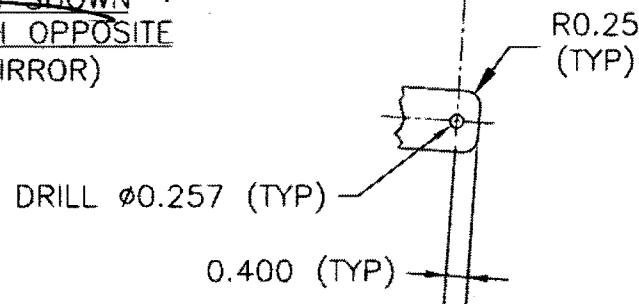
RELEASED
KE 79.06.10



~~D2013-3 LH SHOWN~~
~~D2013-4 RH OPPOSITE~~
(FOR 212 MIRROR)



VIEW A-A



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DART



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
CHECKED	KE	APPROVED	[Signature]	DRAWING NO. D2013	SHEET 2 OF 3
DATE	99.06.07	TITLE	MIRROR BRACKET	SCALE	NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

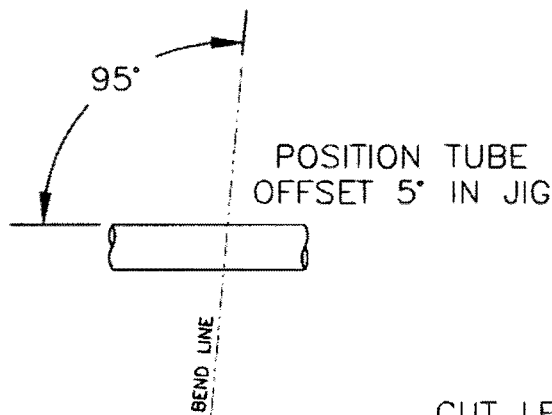
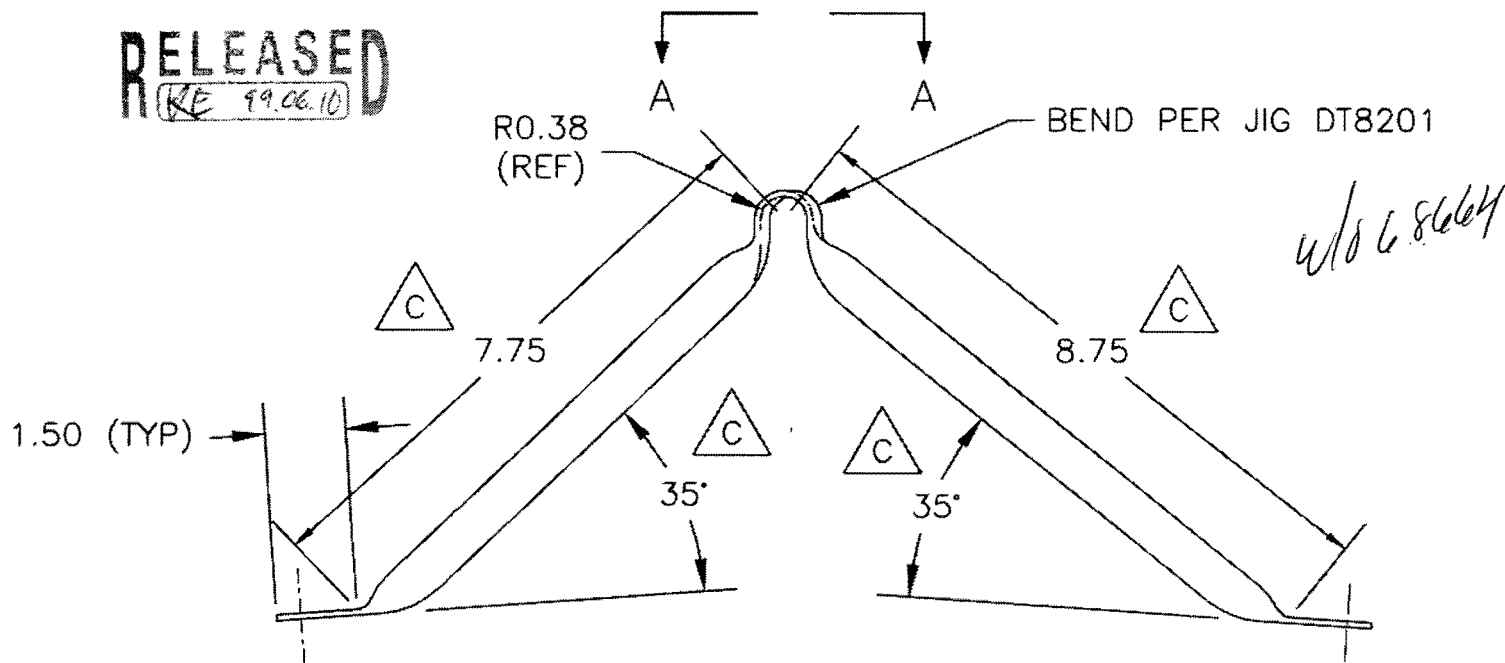
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RELEASED
(KE 99.06.10)

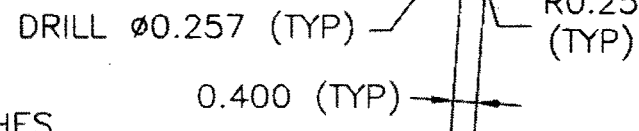
DART

QA COPY ISSUED



VIEW A-A

D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)



CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DESIGN	JB	DRAWN BY	RM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	DRAWING NO. D2013
DATE	99.06.07			SHEET 3 OF 3
				SCALE
				NTS
				TITLE
				MIRROR BRACKET

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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